

**WHAT IS CLAIMED IS:**

1. A method of securing friction liners on an annular support plate, the support plate having an outer periphery defining a radial blade having opposed lateral faces including at least one lateral fastening face which defines an adhesion zone of predetermined form positioned on the fastening face, the method being a method of adhesively bonding the said friction liners on at least one said lateral fastening face and comprising:

- an adhesive applying step which consists in depositing a predetermined quantity of adhesive on a said adhesion zone, wherein said deposition of adhesive is carried out by means of an adhesive applicator defining an adhesive applying zone the form of which corresponds to that of the said adhesion zone.

2. A method according to Claim 1, wherein the adhesive applying step comprises:

- a first, impregnation, phase which comprises impregnating with adhesive the said adhesive applying zone of the applicator head,

- and a second, adhesive applying, phase which comprises the step of bringing the impregnated adhesive applying zone of the applicator head into contact, under axial pressure, with the said adhesion zone, whereby to transfer a predetermined quantity of adhesive from the applicator head to the said blade of the support plate.

3. A method according to Claim 2, wherein the said second phase further includes applying a backing head against the lateral face of the said blade opposed to the said lateral fastening face, whereby to apply on the said opposed face an axial force opposite to that exerted by the

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applicator head on the said lateral fastening face, thereby avoiding deformation of the blade.

4. A method according to Claim 1, wherein, the said opposed lateral faces of each said radial blade being fastening faces, the adhesive applying step comprises the use of two applicator heads, each having a said adhesive applying zone, the said adhesive applying zones being in facing relationship to the said adhesion zones of each of the lateral fastening faces, the applicator heads being applied to the two fastening faces simultaneously.

5. A method according to Claim 1, further including, following the adhesive applying step, rotating the support plate whereby to put the said adhesion zone on the fastening face of a further said radial blade of the support plate into a position opposite the adhesive applying zone of the applicator head.

6. A method according to Claim 5, further including a step of controlling the application of adhesive to at least one said lateral fastening face.

7. A method according to Claim 6, wherein the said control step comprises using an optical system to detect the presence of adhesive on the said support plate but outside the said adhesion zone.

8. A method according to Claim 6, wherein the said control step comprises using an optical system to detect absence of adhesive on at least part of the adhesion zone.

9. A method according to Claim 8, further including the step of rejecting the support plate when the said optical system detects at least one situation selected from the group consisting of the presence

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of adhesive or support plate but outside the adhesion zone and absence of adhesive on at least part of the adhesion zone.

10. A method according to Claim 8, wherein the said control step comprises using the said optical system to determine the real position  
5 of the said adhesion zone, carrying adhesive, with respect to the corresponding said lateral fastening face of the said blade, the control step further including comparing the said real position with a theoretical position of the adhesion zone, and rejecting the support plate if the two said positions are different from each other.

10 11. Apparatus for the adhesive fastening of friction liners on an annular support plate, the said plate having an outer periphery defining at least one radial blade having opposed lateral faces, including at least one fastening face, with an adhesion zone on at least one said lateral fastening face, the apparatus being apparatus for fastening said  
15 friction liners adhesively on at least one said lateral fastening face of the support plate, the apparatus including means for depositing a predetermined quantity of adhesive on said adhesion zone, said deposition zone comprising at least one adhesive applicator head defining an adhesive applying zone, and means defining a hollow receptacle for containing adhesive, the apparatus further including  
20 means for moving the applicator head between said hollow receptacle and said adhesion zone whereby to take adhesive from the hollow receptacle and deposit the said adhesive in a predetermined quantity on the adhesion zone, the said hollow receptacle being selected from  
25 the group consisting of a reservoir and a shallow recess.

12. Apparatus according to Claim 11, further including means for applying axial pressure between the applicator head and the said adhesion zone, whereby the applicator head can deposit the said

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predetermined quantity of adhesive on the adhesion zone by contact, under axial pressure, of the adhesion applying zone of the head with the adhesion zone of the support plate.

13. Apparatus according to Claim 12, further including a backing  
5 head for applying counter-pressure against the lateral face of the blade opposed to the lateral fastening face of the blade to which adhesive is to be applied, the said backing head being disposed in opposition to the adhesive applicator head so as to exert an axial force opposed to axial forces exerted by the applicator head, whereby to avoid  
10 deformations of the said blade.

14. Apparatus according to Claim 11, further including means for carrying said support plate and rotating the latter whereby to locate successive lateral fastening faces of different said blades of the support plate in facing relationship with the adhesive applying zone of the applicator head.  
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15. Apparatus according to Claim 14, wherein the said means for rotating the support plate include indexing means for positioning successive said adhesion zones in facing relationship with the adhesive applying zone of the applicator head.

20 16. Apparatus according to Claim 11, further including means for monitoring the said adhesion zones carrying adhesive.

17. Apparatus according to Claim 16, wherein the said control means comprise an optical viewing device for viewing the said lateral fastening faces, whereby to monitor at least one characteristic  
25 selected from the group consisting of the position of the adhesive zone and the distribution of adhesive on the lateral fastening face.

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18. Apparatus according to Claim 16, wherein the said control means include a weighing device for detecting the quantity of adhesive deposited on at least one said adhesion zone.

19. Apparatus according to Claim 11, having two said applicator  
5 heads, situated in opposed relationship with each other and arranged in facing relationship with two respective opposed adhesion zones of a said blade.

20. Apparatus according to Claim 11, further including a receptacle  
10 for a reserve supply of adhesive, an adhesive reservoir, and feed means connecting the said reservoir with the said receptacle, whereby to maintain adhesive in the reservoir at a filling level higher than a predetermined limiting lower level.

21. Apparatus according to Claim 11, further including a device for cleaning the adhesive applying zone of the adhesive applicator.

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